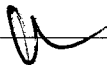


119828
2:24:28 PM

119828

Page 1

Item ID: D3322-042 Accept *N900040100* Setup Start *NS1*
Revision ID:
Item Name: Pod Assembly Stop *NS2*
Start Date: 5/26/14 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 7/04/14 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3322	Rev A								

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 24371

Description:

D2202-1Pod Lid

D2202-5Pod Base

Supplier: Delastek

Copy of Certificate of Conformity and Process sheet from Delastek is required

CD 14/05/28 ①
D 3048-1 x 1 B 100618
shp to Delastek - D 3001-1 x 3 B 113456

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity and process sheet from Delastek is attached

1x SP14-6-25

Work Order ID 119828***119828***

Page 2

May-26-14 2:24:28 PM

Item ID: D3322-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pod Assembly

Start Date: 5/26/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/04/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Visual inspection. Check for void spot and pins. Check over all dimensions as per Dwg D2202.

JMP
14/6/26

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D2694 & D3322

14-06-27 (X1)

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS

27

9-89

4/7/13

1

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *sh*

Date: 14/08/14

QA Closed: *sh*

Date: 14/7/18

Work Order: <u>119828</u> Part No. <u>D3322-042</u> NCR No. <u>14-4050</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input checked="" type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input checked="" type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>	14-06-27	130	38	used AD62 AD64ABS rivets instead of AD62ABS rivets in hinge Pick 1/cit was not updated to match drawing	DAS 12 9-89 14/6/27	Acceptable	DAS 12 9-89 14/6/27	14/6/27	14/6/27		

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input checked="" type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

DQA:

AK

Date:

14/08/01

QA Closed:

AK

Date:

14/7/18

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>119828</u> Part No. <u>D3322-042</u> NCR No. <u>14-4051</u>				DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input checked="" type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering Quality <input type="checkbox"/> Other <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design <input type="checkbox"/>	<u>14/07/18</u>	<u>#140</u>	<u>N</u>	Found AT inspection that the inside of the Pod has a very noticeable left over of Blue Residue found on both Base & Lid. RC Employee Did not clean all Residue before it cured / operate 57mm.	DAS 16 9-89 Q32042 14/07/18	Scuff all Entry + Remove Residue. Reprim as per DM + Q32005	AS 14-7-2	DAS 27 9-89 14/7/18	DAS 16 9-89 Q32042 14/07/18		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Handling/Pre <input type="checkbox"/>											
Material <input type="checkbox"/>											
Operator <input checked="" type="checkbox"/>											
Offset/Setup <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Transport <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input checked="" type="checkbox"/> Finish <input type="checkbox"/> Fit/Function			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence			<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

May-26-14 2:24:28 PM

1 19828

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/26/14 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/04/14 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.00

Packaging

DAS
06
9-89

~~JUL 03 2014~~

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 140703

и 440703

Picklist Print

May-26-14 2:29:15 PM

Page 1

Work Order ID: 119828

119828

Parent Item: D3322-042

D3322-042

Parent Item Name: Pod Assembly

Start Date: 5/26/14

Required Date: 7/04/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A04.11.12New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AD64ABS		Purchased	No			130	Each	604.0000	38	38			
---------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

AD64ABS

Pop Rivet

DAS
10
9-89

AD62ABS

Location

Loc Qty

Loc Code

ST278

104

123969

46

125447

58

ST553

500

M128728

500

**

21 14-06-26

AN4-5A

Purchased

No

130

Each

367.0000

19

19

AN4-5A

BOLT

**

21 14-06-26

Location

Loc Qty

Loc Code

ST355

367

120562

263

15247

4

m127817

100

x19

AN4-6A

Purchased

No

130

Each

2,716.000

1

1

AN4-6A

BOLT

**

21 14-06-26

Location

Loc Qty

Loc Code

ST355

604

16067

4

M128403

600

ST514

2112

M126317

350

M128634

1762

21

Picklist Print

May-26-14 2:29:15 PM

Page 2

Work Order ID: 119828

119828

Parent Item: D3322-042

D3322-042

Parent Item Name: Pod Assembly

Start Date: 5/26/14

Required Date: 7/04/14

Start Qty: 1.00

Required Qty: 1.00

AN526C632R7

Purchased

No

130

Each

3.0000

2

2

AN526C632R7

Screw

**

ET 14-06-26

Location

Loc Qty

Loc Code

ST345

3

112385

2

117317

1

X2

D2202-1P

Purchased

No

Each

0.0000

1

D2202-1P

Side Pod Lid, 350

**

1X SP 14-6-25

D2202-5P

Purchased

No

Each

0.0000

1

D2202-5P

Side Pod, Base 350

**

1X SP 146-25

D2204-9

Manufactured

No

130

Each

19.0000

5

5

D2204-9

Rubber Latches

**

ET 14-06-26

Location

Loc Qty

Loc Code

st238

19

107654

5

111010

9

113537

2

85081

3

X5

D2429-041

Manufactured

No

130

Each

9.0000

1

1

D2429-041

Spring Clip Ass'Y

**

ET 14-06-26

Location

Loc Qty

Loc Code

ST010

9

107585

6

81895

3

X1

May-26-14 2:29:16 PM

Shop Packet Print

Page 2

Picklist Print

May-26-14 2:29:16 PM

Page 3

Work Order ID: 119828

119828

Parent Item: D3322-042

D3322-042

Parent Item Name: Pod Assembly

Start Date: 5/26/14

Required Date: 7/04/14

Start Qty: 1.00

Required Qty: 1.00

D2462 *D2461 = 1700*
D2462
 Seal (Per foot) **DAS 10 9-89**

Manufactured No

130 f

576.2980 14.17 15

ET 14-06-26

8114238

Location

Loc Qty

Loc Code

ST402

76.298

98802

76.298

ST402A

500

115832

500

D2528-1

Manufactured No

130 Each

10.0000 5 5

ET 14-06-26

D2528-1

Backer Plate

Location

Loc Qty

Loc Code

ST011

10

82334

10

D2528-3

Manufactured No

130 Each

4.0000 4 4

ET 14-06-26

D2528-3

Backer Plate

Location

Loc Qty

Loc Code

ST011

4

107611

2

65085

2

D2569

Manufactured No

130 Each

0.0000 1 1

ET 14-06-26

D2569

Hinge

D3001-1

Manufactured No

130 Each

12.0000 3 3

CD 14/05/28

D3001-1

Doubler

Location

Loc Qty

Loc Code

ST178

12

113456

10

99490

2

May-26-14 2:29:16 PM

Shop Packet Print

Page 3

Picklist Print

May-26-14 2:29:16 PM

Page 4

Work Order ID: 119828

Parent Item: D3322-042

Parent Item Name: Pod Assembly

119828

D3322-042

Start Date: 5/26/14

Required Date: 7/04/14

Start Qty: 1.00

Required Qty: 1.00

D3007-041

Manufactured No

130

Each

2.0000

1

1

D3007-041

Prop Assy

BT 14-06-26

Location

Loc Qty

Loc Code

ST259

2

107599

1

84300

1

X 1

MS21042L06

Purchased

No

130

Each

511.0000

2

2

MS21042L 06

Nut

BT 14-06-26

Location

Loc Qty

Loc Code

ST314

511

m127304

20

m128401

200

m128754

91

m128976

200

X 2

MS21042L4

Purchased

No

130

Each

6,436.000

20

20

MS21042L 4

Locknut

BT 14-06-26

Location

Loc Qty

Loc Code

ST314

50

m124231

6

m126015

12

m126275

32

ST509

6375

m127255

71

m127813

988

m128300

316

m128798

5000

X 20

ST518

11

m127376

11

May-26-14 2:29:16 PM

Shop Packet Print

Page 4

Picklist Print

May-26-14 2:29:16 PM

Page 5

Work Order ID: 119828

119828

Parent Item: D3322-042

D3322-042

Parent Item Name: Pod Assembly

Start Date: 5/26/14

Required Date: 7/04/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

130

Each

5,916.000

21

21

NAS1149D0463.J

WASHER

**

BT 14-06-26

Location

Loc Qty

Loc Code

ST510a

5916

16941

8

M124778

18

M126221

20

M127813

22

M127904

3000

M128591

1348

M128995

1500

X21

NAS1149DN632J

Purchased

No

130

Each

485.0000

2

2

NAS1149DN632.J

Washer

**

BT 14-06-26

Location

Loc Qty

Loc Code

ST293

485

M126084

11

M127255

100

M128812

374

X2

ADG6ABS

Qty (x2) Batch: 112784

BT 14-06-26

ADG4ABS

Qty (x42) Batch: 123869
128728 x 19
x 23

BT 14-06-26

DAS
10
9-89

May-26-14 2:29:16 PM

Shop Packet Print

Page 5

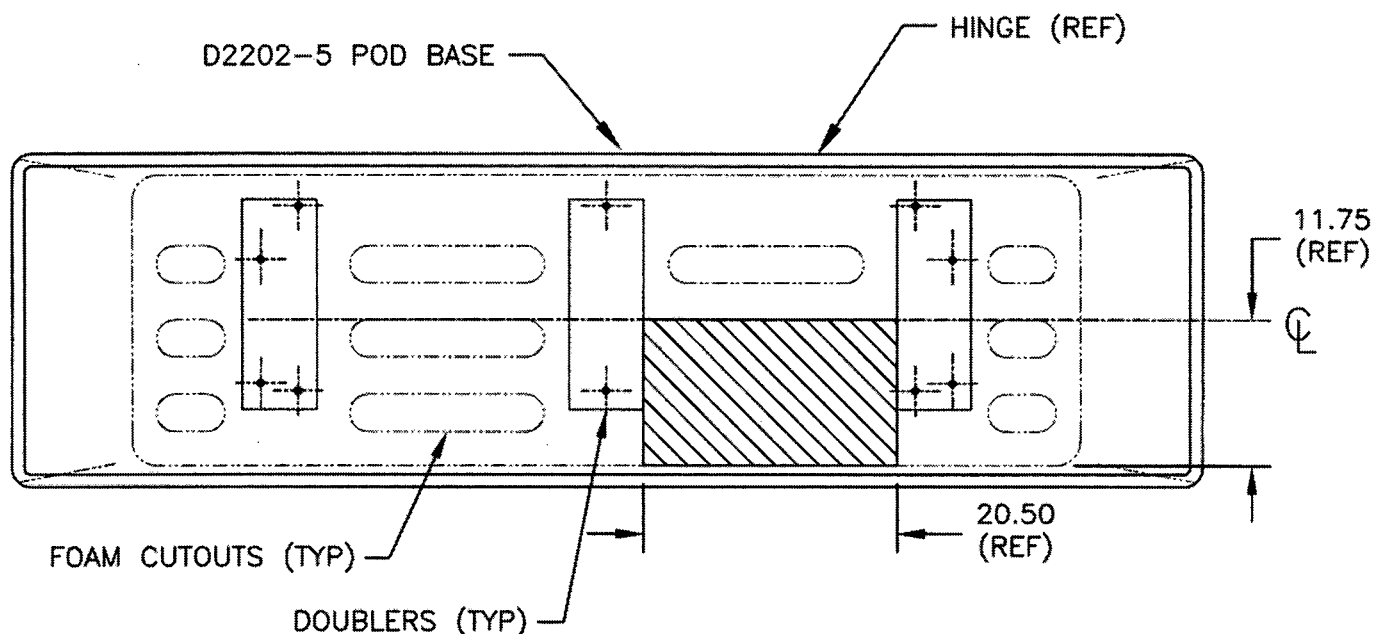


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3322	REV. A SHEET 1 OF 1
DATE 04.09.26		TITLE POD ASSEMBLY	SCALE 1:15
A	04.09.26	NEW ISSUE	

RELEASED
04.10.29 *#*

D3322-041/-042 POD ASSEMBLY

- 1) THE D3322-041/-042 POD ASSEMBLIES ARE THE SAME AS THE D2694 POD ASSEMBLIES, EXCEPT THE D2202-3 POD BASE IS REPLACED WITH THE D2202-5 POD BASE



D3322-041 POD ASSEMBLY (SHOWN)
D3322-042 POD ASSEMBLY (OPPOSITE)

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NOTES:**1) MATERIALS:**

RESIN: EPOCAST 50-A/9816,
OR DERAKANE 470-36/411/510A40

FOAM: A500 CORE CELL,
OR DIVINYCELL,
OR AIREX,
0.38 THICK (3/8 FOAM)

FIBRE: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
5 oz PLAIN WEAVE KEVLAR (5 oz KEVLAR)

2) FINISH: INSIDE = PRIME PER DART QSI 005 4.2
OUTSIDE = WHITE GELCOAT #GEL 944W005

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) LAMINATE PER DART QSI 006.
LAMINATION SCHEDULE PER THIS DRAWING.

9) PEEL PLY ALL SURFACES.

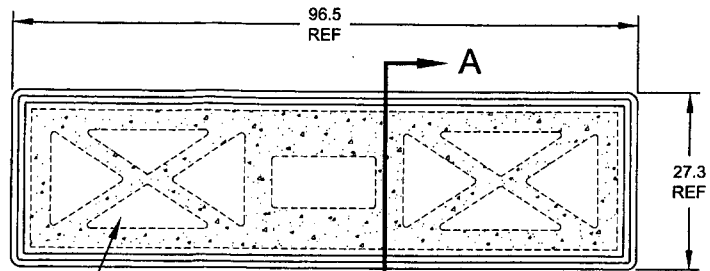
RELEASED
2010-10-28

CL 14105128
W10' 119828

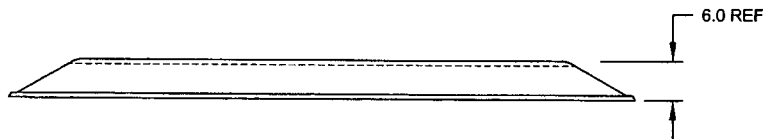
G	REFORMAT DRAWING TO CURRENT STANDARDS: D2202-101 WAS D2202-1 (ZN C5-2, A4-2); ADD 77.5 & 22.0 DIM. (ZN D4-3, C6-3); D2202-103 WAS D2202-5 (ZN C5-3, A4-3); ADD 2.00 MAX (ZN D3-4); INCORPORATED DEO 9217 & ADD D2202-5/6 ON SHEET 5 PER PAR 09-034	RF	09.10.06
F	CHANGE LAYUP, DOUBLER, NOW DRILLED	CP	01.03.14
E	ADDED SECTIONS WITH LIP DIMS	KE	99.11.11
D	MOVED DOUBLERS, REMOVED HOLES	KE	98.11.09
C	REVISED DOUBLER/HOLES LOCATIONS	KE	97.07.04
B	ADD DOUBLERS AND HOLES	-	93.10.27
A	NEW ISSUE	-	93.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 1 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SEE
DETAIL B
A8-2

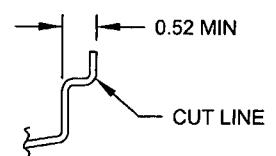
SECTION A-A C3-2



G
D2202-101 FOAM CORE,
MAKE FROM 3/8" FOAM, ROUTER PER DT8024



D2202-1 LID
(MOLD DT8002)



DETAIL B
SCALE 10X
D6-2

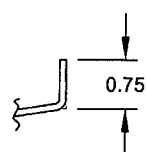
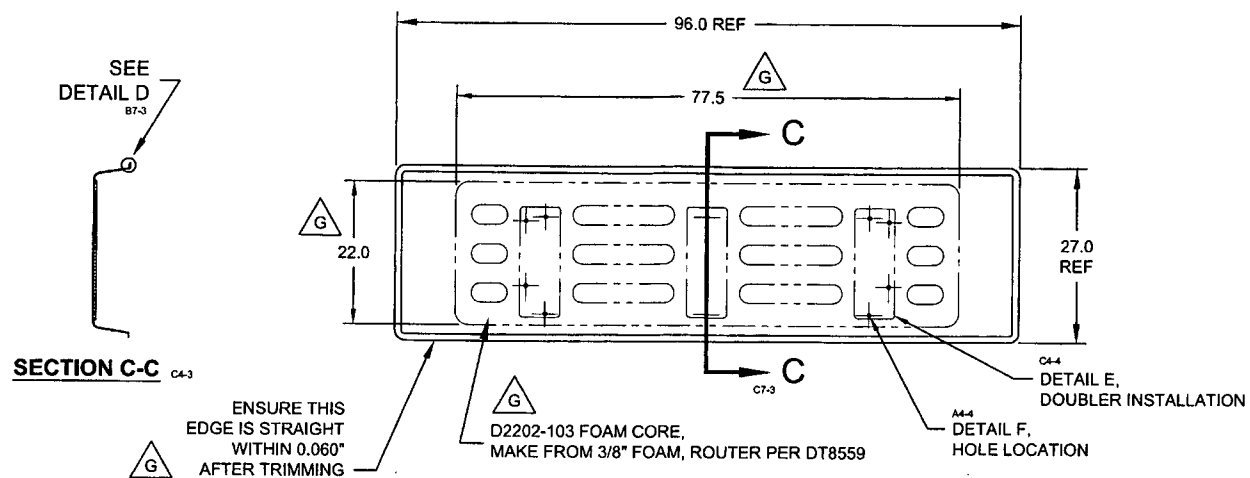
MAIN LAYUP
9oz SATIN
9oz SATIN
5oz KEVLAR
D2202-101 FOAM CORE
5oz KEVLAR
9oz SATIN

G

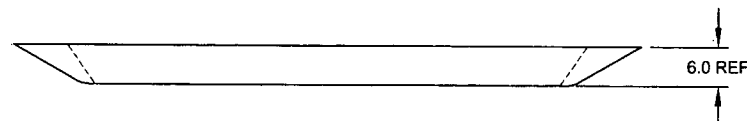
RELEASED
2010-10-28

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DESIGN	KE	
DRAWN	RF	
CHECKED	<i>JP</i>	DRAWING NO. REV. G
MFG. APPR.	JM	D2202 SHEET 2 OF 5
APPROVED	<i>JP</i>	TITLE SCALE
DE APPR.	<i>JP</i>	UTILITY POD LID AND BASE NTS
DATE	09.10.06	

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DETAIL D
SCALE 10X
D7-3



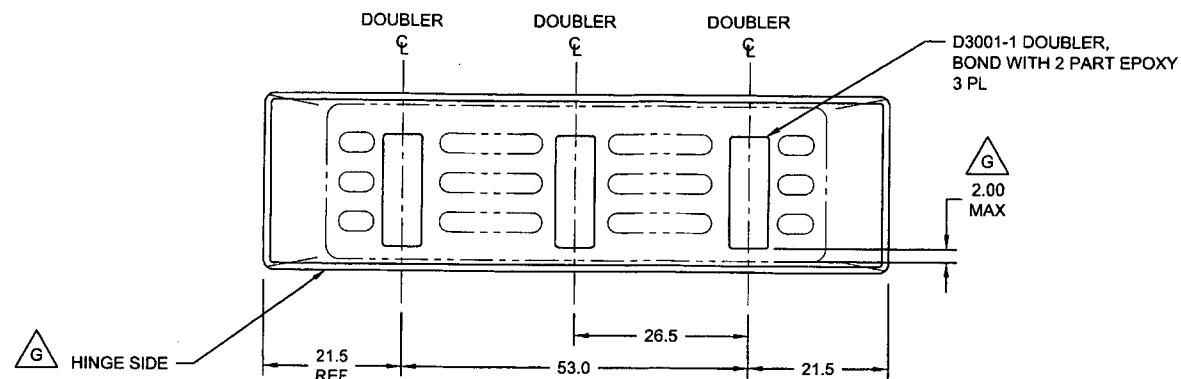
D2202-3 BASE
(MOLD DT8002)

MAIN LAYUP

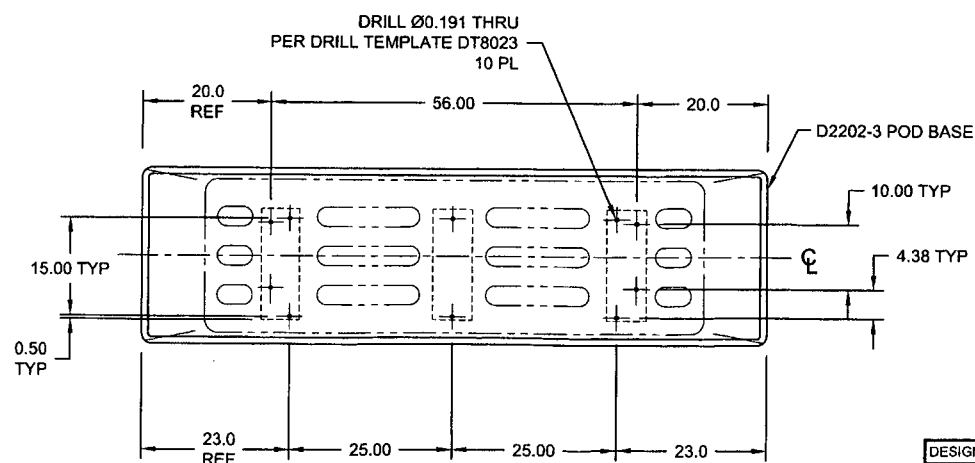
9oz SATIN
9oz SATIN
5oz KEVLAR
D2202-103 FOAM CORE
5oz KEVLAR
5oz KEVLAR
9oz SATIN

RELEASED
2010-10-28

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 3 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DETAIL E: INSTALLATION OF D3001-1 DOUBLERS C3-3



DETAIL F: HOLE DRILLING C3-3
(AFTER DOUBLER INSTALLATION)

RELEASED
R 2010-10-28

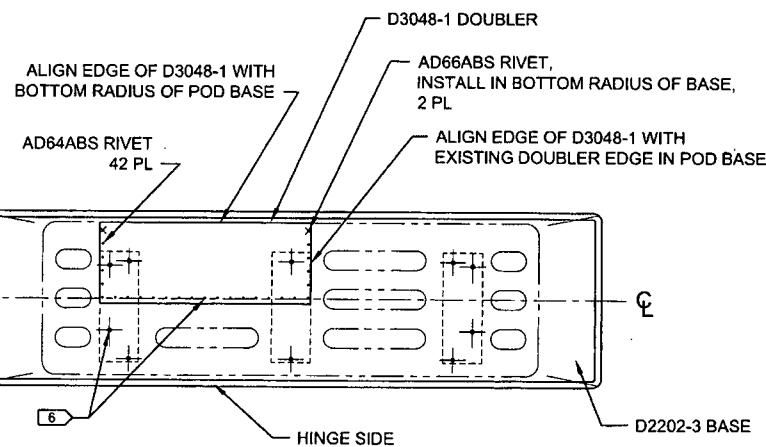
DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 4 OF 5
APPROVED	JP	TITLE	SCALE
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NOTES : TO MAKE A D2202-5/6 BASE (FOR D350-602-013-014) FROM A D2202-3 BASE

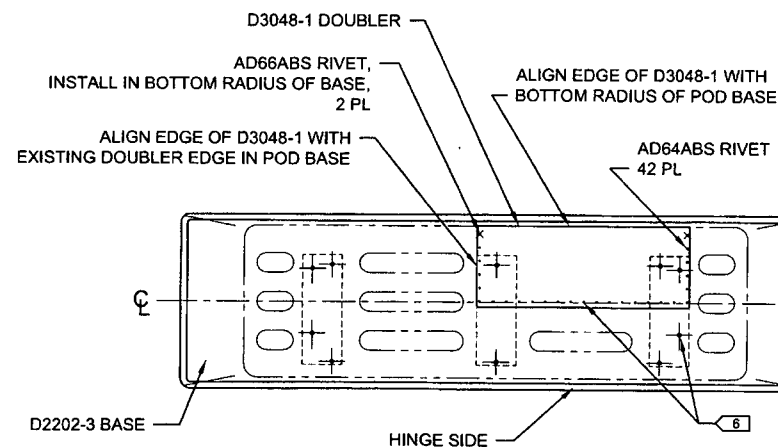
- 1) REMOVE FOAM IN AREA OF POD BASE WHERE D3048-1 DOUBLER WILL BE INSTALLED
- 2) FILL GAPS WITH 9oz SATIN AND RESIN PER DWG (APROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 9oz SATIN
- 4) BOND D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) TRANSFER Ø0.125 HOLES FROM D3048-1 TO POD BASE. INSTALL DOUBLER WITH AD64ABS RIVETS (42) AND AD66ABS (2)
- 6) TRANSFER Ø0.191 HOLES FROM POD BASE TO D3048-1. SEAL HOLES WITH CYANOACRYLATE GLUE
- 7) TOUCH UP AFFECTED AREA WITH GREY PRIMER PER DWG
- 8) FILL CENTER OF THE AD RIVETS WITH RTV 732 TO SEAL

PART LIST:

QTY -5	QTY -6	PART NUMBER	DESCRIPTION
X		D2202-5	POD BASE
	X	D2202-6	POD BASE
1	1	D2202-3	BASE
1	1	D3048-1	DOUBLER
42	42	AD64ABS	RIVET
2	2	AD66ABS	RIVET
A/R	A/R	RTV	SEALANT



D2202-5 BASE: D3048-1 DOUBLER INSTALLATION
(MAKE FROM D2202-3 BASE)



D2202-6 BASE: D3048-1 DOUBLER INSTALLATION
(MAKE FROM D2202-3 BASE)

RELEASED
2010-10-28

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 5 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24371

Purchase Order Date 5/28/2014

PO Print Date 5/28/2014

Page Number 1 of 2

Order From :

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
613 632 1053

Contact Name

Vendor Phone 819 533 5788

Ship To Contact

Ship To Phone

Ship Via:

FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2202-1P AS PER DWG D2202 REV. G B119828	Side Pod Lid, 350	7/4/2014 Yes 7/4/2014		1.00 Each	\$2,890.60	\$2,890.60
						Line Total:	\$2,890.60
2	D2202-5P AS PER DWG D2202 REV. G B119828	Side Pod, Base 350	7/4/2014 Yes 7/4/2014		1.00 Each	\$2,890.60	\$2,890.60
						Line Total:	\$2,890.60

SP14-6-25

Note:

5/28/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	57635
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
23-06-2014	28-05-2014	24686	Chantal Lavoie	PO24371	Net 30 days USA
Ship Via		F.O.B.	Salesperson		GST/PST
FEDEX P1 Collect		Point de départ	Jocelyne Laurin, 221		
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0073	Line #1 D2202-1 Side Pod Lid B119828 U of M: Chaque Référence DKA362-0015 DWG: REV. G Lot # 62083 1	
1	0	1	DKC134-0075	Line #2 D2202-5 Side Pod Base B119828 U of M: Chaque DWG: D2202 Rév.: G Lot # 62082 1	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Mathieu Ayotte
Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mercredi, 2014-05-28 15:21:16
Utilisateur: marc dubé

Feuille de Procédé

Client :	DART US DART AEROSPACE	Nom Dessin :	UTILITY POD LID
Numéro Job :	62083	Numéro Article :	DKC134-0073
Numéro :	4347	Numéro Dessin :	D2202
Numéro B.A. :		Projet Numéro :	DK-362
Cette fois :	2014-05-28 No. :	Révision dessin :	G
Prsht Rev. :	NC	Matériel :	Resine Darakane 470-36/411/510
Prem. fois :	-- Type :	Date Dûe :	2014-06-04 Qté: 1 Ud UNITE
Job précédente :	59756		

Écrit par : _____
Vérifié & Approuvé par : _____
Commentaires : N° de Pièce Client: D2202-1



COPIE

Process Sheet Rév.: 03 Ajout de la IF134-0008 à la séquence 35.0.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo

Comment Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 1-42289-1

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT8002 selon IG 0009.

Date: 6/06/14 Sceau: _____



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Comment Qty.: 1.250 KILOGRAMME(s)/Unit Total : 1.250 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-43003-2

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Comment Qty.: 0.0095 GALLON(s)/Unit Total : 0.0095 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-2829-1

5.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs




Appliquer le gel coat selon IG 0019.

Date: 6/06/14 Sceau: _____
















Date: Mercredi, 2014-05-28 15:21:17
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: UTILITY POD LID	
Numéro Job: 62083	Numéro DKC134-0073	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
6.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
Comment	Qty.: 9.90 VERGE(s)/Unit Total : 9.90 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	N° de Lot: 1-44353-3
7.0	AAC1885	Tissu à délaminer Release ply B
Comment	Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s) Tissu à délaminer Release ply B	# de Lot: N/A
8.0	AAC1608	5oz plain weave Kevlar 50" wide roll
Comment	Qty.: 6.60 VERGE(s)/Unit Total : 6.60 VERGE(s) 5oz plain weave Kevlar 50" wide roll	N° de Lot: 1-42765-1
9.0	AAC1887	Wrightlon 5200 Bleu P3
Comment	Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s) Wrightlon 5200 Bleu P3	# de Lot: N/A
10.0	AC0885	Feutre de drainage N° Airweave N 10
Comment	Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)	
11.0	AC0943	Stretchlon 200 poche à vide Vert
Comment	Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)	
12.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
Comment	Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)	
13.0	TAILLAGE	Faire le taillage du matériel
		
		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs	
Faire le taillage du matériel selon les Dimensions requises:		
Un morceau pour recouvrir le fond du moule N° DT8002.		
Deux morceaux pour couvrir les extrémités du moule N° DT8002.		
Deux morceaux pour recouvrir les cotés du moule N° DT8002.		
Faire cette opération pour les trois plis de 9 oz ainsi que pour les deux plis de 5 oz de Kevlar.		
Tailler le matériel nécessaire pour la poche à vide (Faire 3 kits car il y aura trois baggings différents lors de la fabrication de cette pièce):		
Peel Ply Film Durisol P-3 Feutre de drainage 6m Stretchlon 200		
Coller une bande de ruban jaune tout le tour du Stretchlon 200, plier les différentes composantes des poches à vide et entreposer en attente des opérations de bagging.		














Date: Mercredi, 2014-05-28 15:21:17
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD LID
Numéro Job:	62083	Numéro	DKC134-0073
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
Date: <u>30/05/14</u> Sceau: 			
14.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-44353-3</u>		
15.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
16.0	PREP-GENERAL	Préparation du matériel	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid : 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 Min. Date: <u>6/06/14</u> Sceau: 		
17.0	LAMINAGE	Faire le laminage	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le laminage des trois premiers plis de tissu (2 plis de 9 oz et 1 pli de 5 oz Kevlar) de la façon suivante: Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 Minutes, ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin) Recommencer pour les deux autres plis. (un pli de 9 oz et un pli de 5 oz Kevlar) Date: <u>6/06/14</u> Sceau:  		
18.0	BAGGING	Faire le bagging sur la pièce	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012 Laisser sécher 4 heures minimum Date: <u>6/06/14</u> Sceau:  		











Date: Mercredi, 2014-05-28 15:21:17
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD LID
Numéro Job:	62083	Numéro	DKC134-0073
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
19.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-45606-1</u>		
20.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
21.0	DKC134-0022	D2202-101 Foam Core (Utility Pod Lid)	
Comment	Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) D2202-101 Foam Core (Utility Pod Lid) N° de Job: <u>62083</u>		
22.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire un mélange de résine Derakane 411-350 Promoté 15 à 18 Minutes 1.5% de catalyst DDM-9 par quantité de résine. Date: <u>2/06/14</u> Sceau: 		
23.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Sceller le Foam Core N° DKC134-0022 selon IG 0105. Date: <u>2/06/14</u> Sceau: 		
24.0	AAC1611	Polybond B46F	
Comment	Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s) Polybond B46F N° de Lot: <u>1-38189-1</u>		
25.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire l'assemblage du Foam Core N° DKC134-0022 à l'aide du polybond 46F selon IG 0033. Date: <u>9/06/14</u> Sceau:  		
26.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012.		

Date: Mercredi, 2014-05-28 15:21:17
Utilisateur: marc dubé















Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD LID
Numéro Job:	62083	Numéro	DKC134-0073
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
<p>Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.</p> <p>Heure début Curing: <u>8:45</u> Heure Fin Curing: <u>10:15</u> Date: <u>9/06/14</u> sceau:  </p>			
27.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-45606-1</u>		
28.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
29.0	PREP-GENERAL	Préparation du matériel	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs <p>Mélanger la quantité de résine désirée pour le laminage des deux derniers plis du Pod Base: 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 minutes.</p> <p>Date: <u>10/06/14</u> sceau: </p>		
30.0	LAMINAGE	Faire le laminage	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs <p>Faire le laminage des deux dernier plis de tissu (1 plis de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:</p> <p>Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 minutes, ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin)</p> <p>Recommencer pour le dernier plis. (un pli de 9 oz)</p> <p>Date: <u>10/06/14</u> sceau:  </p>		

Date: Mercredi, 2014-05-28 15:21:17









Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD LID
Numéro Job:	62083	Numéro	DKC134-0073
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
35.0	TRIMAGE	Trimage	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Faire le trimage du Pod Lid selon la IF134-0008.		
Date:	11/06/14	Sceau:	
36.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.4300 UNITE(s)/Unit Total : 0.4300 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-46475-2		
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-46475-2		
38.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008		
Date:	13/06/14	Sceau:	 # Fiche de Mélange: 6620
39.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Faire le sablage au grit 180 de la surface primée pour enlever les imperfections restantes.		
Date:	17/06/14	Sceau:	 
40.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-46475-2		
41.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-46475-2		
42.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008		
Date:	17/06/14	Sceau:	 # Fiche de Mélange: 6621

Date: Mercredi, 2014-05-28 15:21:17
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: UTILITY POD LID	
Numéro Job: 62083	Numéro DKC134-0073	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
43.0	INSPEC FINAL	Inspection finale
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		<i>visuel interne</i> 
Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.		
Date: <u>18/06/14</u> Sceau: 		
44.0	EMBAL / ENTREPO	Emballage & Entreposage
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Emballer et entreposer selon IG 0057		
Date: <u>19 JUIN 2014</u> Sceau: 		

Date: Mercredi, 2014-05-28 15:21:16
Utilisateur: marc dubé

Feuille de Procédé

Client	: DART US DART AEROSPACE	Nom Dessin	: UTILITY POD BASE
Numéro Job	: 62082	Numéro Article	: DKC134-0075
Numéro	: 4345	Numéro Dessin	: D2202
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2014-05-28 No. :	Révision dessin	: G
Prsht Rev.	: NC	Matériel	: Resine Darakane 470-36/411/510
Prem. fois	: - - Type :	Date Due	: 2014-06-04 Qté: 1 Ud UNITE
Job précédente	: 59757		

Écrit par : _____

Vérifié & Approuvé par : _____

Commentaires : N° de Pièce Client: D2202-5

Process Sheet Rév.: 02 AAC1885 était AC0883,
AAC1887 était AC0884

COPIE

Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Comment Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 1-42289-1

2.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule DKO-0331 selon IF134-0011.

Date: 2/06/14 Sceau:



3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Comment Qty.: 1.250 KILOGRAMME(s)/Unit Total : 1.250 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-43003-2

4.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0095 GALLON(s)/Unit Total : 0.0095 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-2829-1

5.0 GEL COAT Application du Gel Coat



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs













Appliquer le Gel Coat sur le moule selon IF134-0011.

Date: 2/06/14 Sceau:



Date: Mercredi, 2014-05-28 15:21:16
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: UTILITY POD BASE	
Numéro Job: 62082	Numéro DKC134-0075	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
18.0	BAGGING	Faire le bagging sur la pièce
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012. Laisser sécher pendant 4 heures minimum. Heure début Curing: <u>10:30</u> Heure Fin Curing: <u>8:00</u> Date: <u>2/06/14</u> Sceau:  		
19.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-45606-1</u>		
20.0	AMB0286	Catalyst N° DDM-9
Comment Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
21.0	DKC134-0021	D2202-103 Foam Core (Utility pod Base)
Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) D2202-103 Foam Core (Utility pod Base) N° de Job: <u>62084</u>		
22.0	PREP-GENERAL	Préparation du matériel
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Sceller le Foam Core N° DKC134-0021 selon IG 0105. Date: <u>2/06/14</u> Sceau: 		
23.0	AAC1611	Polybond B46F
Comment Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s) Polybond B46F N° de Lot: <u>1-38189-1</u>		
24.0	ASSEMBLAGE	Assemblage mécanique
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Positionner et coller le Foam Core N° DKC134-0021 selon IF134-0011. Date: <u>3/06/14</u> Sceau:  		

Date: Mercredi, 2014-05-28 15:21:16
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 62082

Nom Dessin: UTILITY POD BASE
Numéro DKC134-0075

Numéro Job:



Séq.: Machine ou Opération: Description :

25.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 10:55

Heure Fin Curing: 12:25

Date: 3/06/14

Sceau:



26.0 DECOUPE Découpe manuelle des pièces



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la découpe manuelle du foamecore selon IF134-0011 point 8.5.

Date: 3/06/14

Sceau:



27.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45606-1

28.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

29.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des derniers tissus selon IF134-0011.

Date: 4/06/14

Sceau:

4297 A.M



30.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.














Laisser sécher pendant 4 heures minimum.

Heure début Curing: 10:30

Heure Fin Curing: 8:00















Date: Mercredi, 2014-05-28 15:21:16
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: UTILITY POD BASE	
Numéro Job: 62082	Numéro: DKC134-0075	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
Date: <u>4/06/14</u> Sceau: <u>4297 A-M</u>  		
31.0	AAC1615	D3001-1 Doubler (Pod Base D2002-3)
Comment	Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s) D3001-1 Doubler (Pod Base D2002-3) N° de Lot: <u>1-46370-2</u>	
32.0	AAC102	Colle Araldite N° 2012 (50ml)
Comment	Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s) Colle Araldite N° 2012 (50ml) N° de Lot: <u>1-44566-1</u>	
33.0	ASSEMBLAGE	Assemblage mécanique
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Coller les trois doubler N° D3001-1 selon IF134-0011. Faire trois petites poches à vide selon IG 0012. Laisser sécher pendant 4 heures minimum. Heure début Curing: <u>10:30</u> Heure Fin Curing: <u>2:30</u> Date: <u>5/06/14</u> Sceau:  	
34.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
Comment	Qty.: 0.030 GALLON(s)/Unit Total : 0.030 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-45373-1</u>	
35.0	FINITION	Finition Générale
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Retirer les trois poches à vide et faire un joint tout autour des trois doubler à l'aide du "Filler" P15-3 et laisser sécher. Date: <u>05-06-14</u> Sceau:  	
36.0	AAC1680	D3048-1 Doubler
Comment	Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) D3048-1 Doubler N° de Lot: <u>1-46370-1</u>	
37.0	LAMINAGE	Faire le laminage
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le laminage des tissus pour épaissir et installer le grand doubler selon IF134-0011.	
















Date: Mercredi, 2014-05-28 15:21:16
Utilisateur: marc dubé


Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD BASE
Numéro Job:	62082	Numéro	DKC134-0075
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	Date: 06-05-14 Sceau:  		
38.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment	Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-45373-1		
39.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la finition de l'intérieur selon IG 0043. Vérifier la surface intérieure du Pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine aux endroits où il y a des bulles d'air. Corriger les imperfections de surface à l'aide du "Filler" P15-3. Laisser sécher jusqu'au lendemain. Date: 6/06/14 Sceau:  		
40.0	DÉMOULAGE	Démoulage de la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le démoulage du Utility Pod Base en faisant bien attention de ne pas endommager la pièce. Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide d'un manche de tournevis. Date: 06-06-14 Sceau: 		
41.0	TRIMAGE	Trimage	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le trimage selon IF134-0012. Date: 6/06/14 Sceau:  		

Date: Mercredi, 2014-05-28 15:21:16
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD BASE
Numéro Job:	62082	Numéro	DKC134-0075
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
42.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.4333 UNITE(s)/Unit Total : 0.4333 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-54556-3		
43.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-40909-1		
44.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer le primer selon IG 0008. Date: 07-06-14 Sceau:  # de Fiche technique: 6616		
45.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Ponçer le "Primer" batisseur selon IG 0008. Date: 10/06/14 Sceau:  		
46.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-46475-2		
47.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-46475-2		
48.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs 13/06/14 # Fiche : 6620 Préparer et appliquer le primer selon IG 0008. Date: 10-06-14 Sceau: 		
49.0	INSPEC FINAL	Inspection finale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin. Date: 12/06/14 Sceau:  DOK 16 juin 2014 		

Refusé le 12 Juin 14 

Date: Mercredi, 2014-05-28 15:21:16
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 62082

Nom Dessin: UTILITY POD BASE
Numéro DKC134-0075

Numéro Job:



Séq.:

Machine ou Opération:

Description :

50.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057.

Date: 19 JUIN 2014 Sceau:



Qty	Part Number	Description
X	D2694	UTILITY POD ASSEMBLY
1	D2202-1	POD LID
1	D2202-3	POD BASE
5	D2204-9	LATCH
1	D2429-041	SPRING CLIP ASSEMBLY
1	D2461-1700	NEOPRENE SEAL
5	D2528-1	BACKER PLATE
4	D2528-3	BACKER PLATE
1	D2569	HINGE
1	D3007-041	PROP ASSEMBLY
19	AN4-5A	BOLT
1	AN4-6A	BOLT
2	AN526C632R7	SCREW
21	AN960JD416	WASHER
2	AN960JD6	WASHER
2	MS21042L06	NUT (OR MS21042-06)
20	MS21042L4	NUT (OR MS21042-4)
38	AD62ABS	RIVET

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER QSI 005 4.2 TO MATCH ORIGINAL FINISH
AS REQ'D TO TOUCH UP FINISH AFTER DRILLING OR ASSEMBLY
INSIDE: DUPONT HIGHBUILD PRIMER GREY 1144-S
OR DUPONT 2K-URETHANE PRIMER GREY 7704-S
OUTSIDE: DUPONT IMRON POLYURETHANE ENAMEL BASE WHITE (555U)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 48.5 lbs
- 8) TRANSFER DRILL UNSPECIFIED HOLES FROM ATTACHING PART AS FOLLOWS: AN526C632 → DRILL Ø0.141
AN4 → DRILL Ø0.257
- 9) SEAL ALL HOLES AND EDGES OF POD WITH CYANOACRYLATE GLUE
- 10) FOR D2569 HINGE:
 - (i) INSTALL RIVET HEADS FROM OUTSIDE OF POD
 - (ii) GRIND TRAILING EDGE OF RIVET TO PERMIT HINGE TO CLOSE
 - (iii) ENSURE ALL RIVET HOLES ARE DRILLED ON THE LARGER HINGE TABS AS SHOWN IN DETAIL A

RELEASED
2010-04-29

I	REFORMAT, D2204-9 LOC SPEC'D (B2-4,B6-4,C2-4,C6-4,B6-5,C6-5), D2461-X WAS D2462-X (D5-1,B1-2), ADD FINISH (B5-1)	CP	10.04.20
H	CHANGED RIVETS FROM AD64ABS TO AD62ABS (PAR#185)	DC	07.07.18
G	REVERT BACK TO D2204-9 LATCH	CP	01.05.08
F	REDESIGN, CHANGE LATCHES & PROP	CP	01.03.20
E	CHANGE DIMENSIONS	RF	99.12.20
D	SEAL & HINGE CHANGE (TSR A1047 & A855/A858); INCLUDED DE09119	CP	99.01.08
C	ADD DOUBLER HOLES, REMOVE FINISH	KE	98.11.12
B	CHANGE RIVET PATTERN, ADD D2429	KE	97.10.08
A	NEW ISSUE CREATED TO REPLACE D350-602-041 AND -043	KE	97.07.02
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D2694	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	10.04.20	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

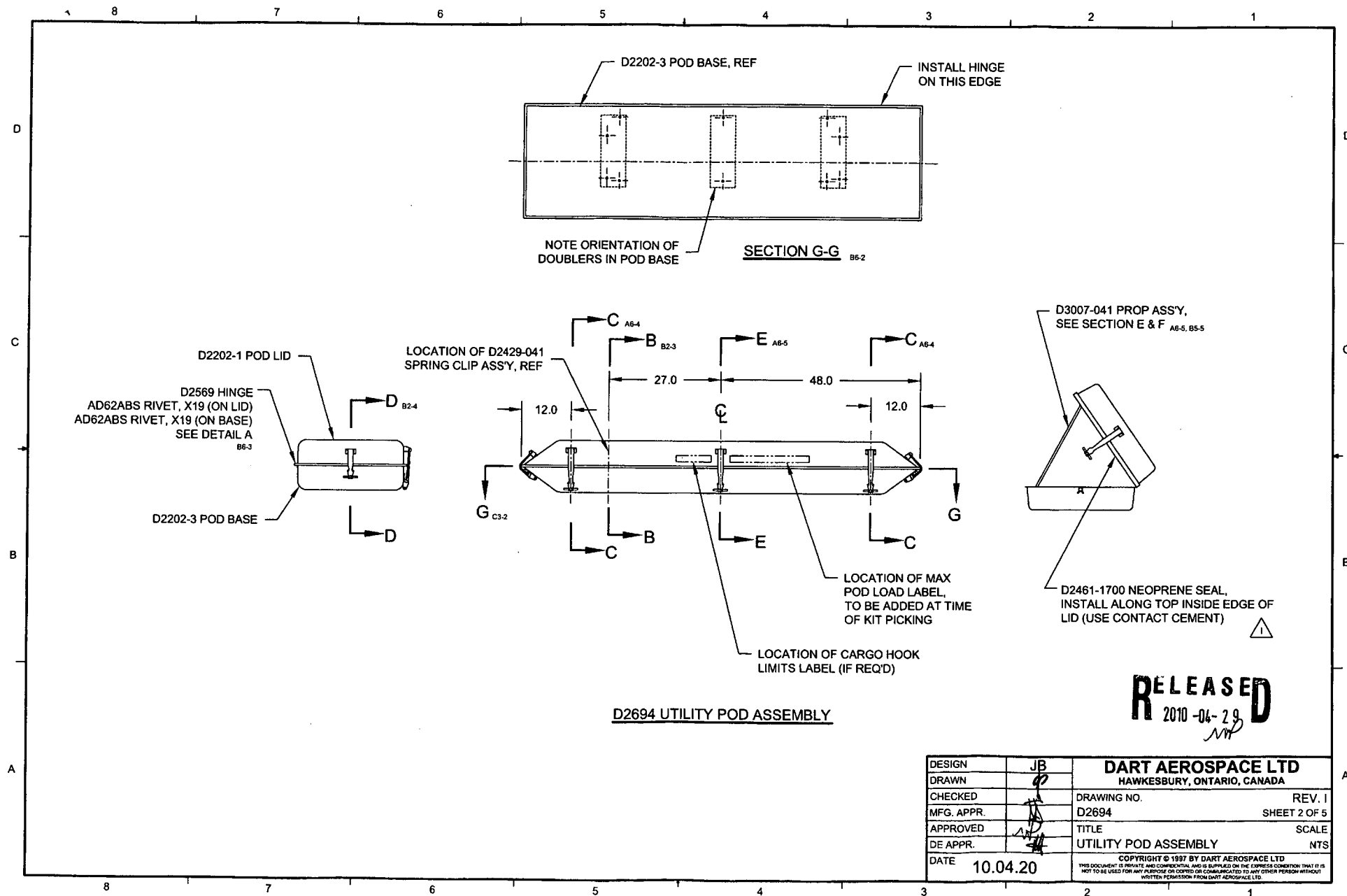
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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8 7 6 5 4 3 2 1

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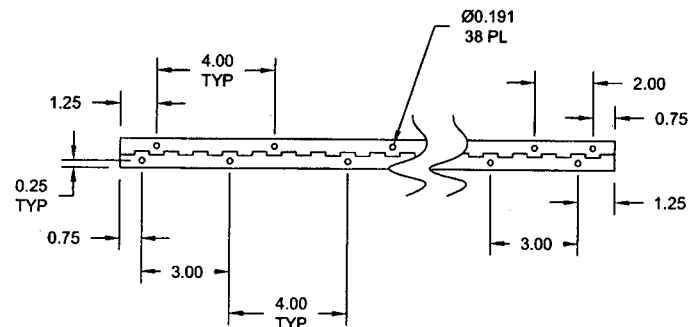
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B

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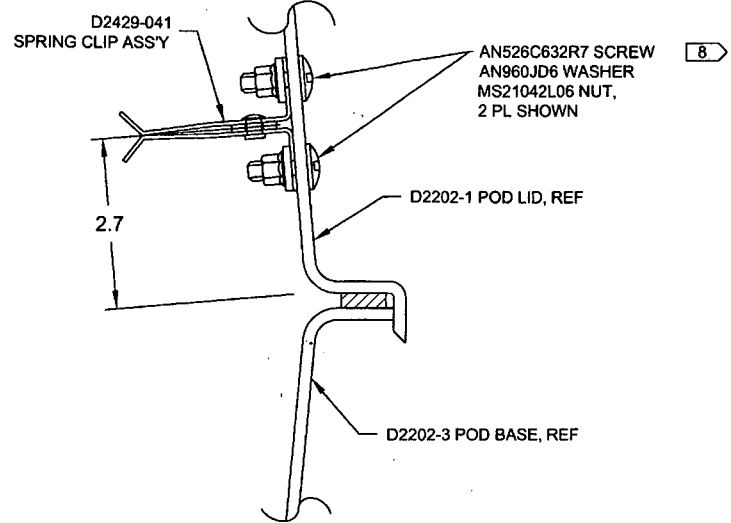
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DETAIL A: HINGE
NOT TO SCALE

10
C7-2



SECTION B-B
NOT TO SCALE

C5-2

RELEASED
2010-04-29
JMD

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMD	DRAWING NO.	REV. I
MFG. APPR.	JMD	D2694	SHEET 3 OF 5
APPROVED	JMD	TITLE	SCALE
DE APPR.	JMD	UTILITY POD ASSEMBLY	NTS
DATE	10.04.20	COPYRIGHT © 1997 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

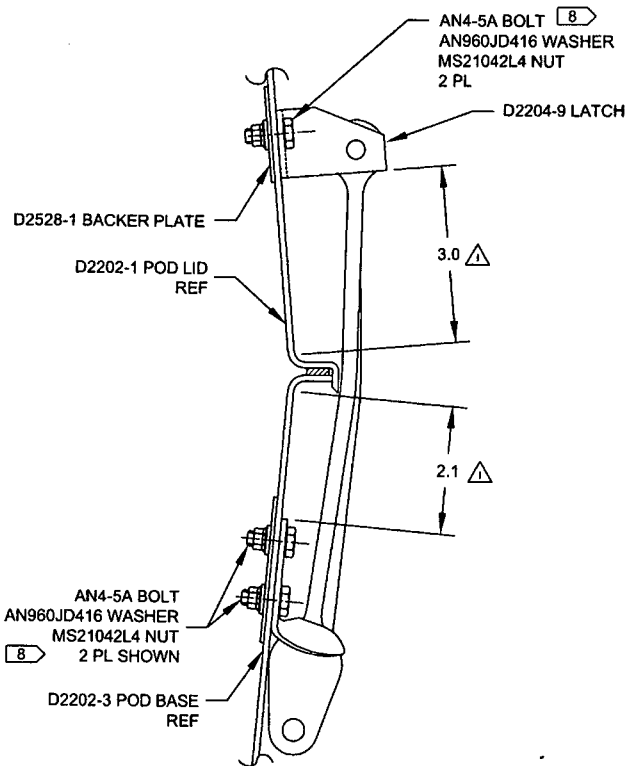
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

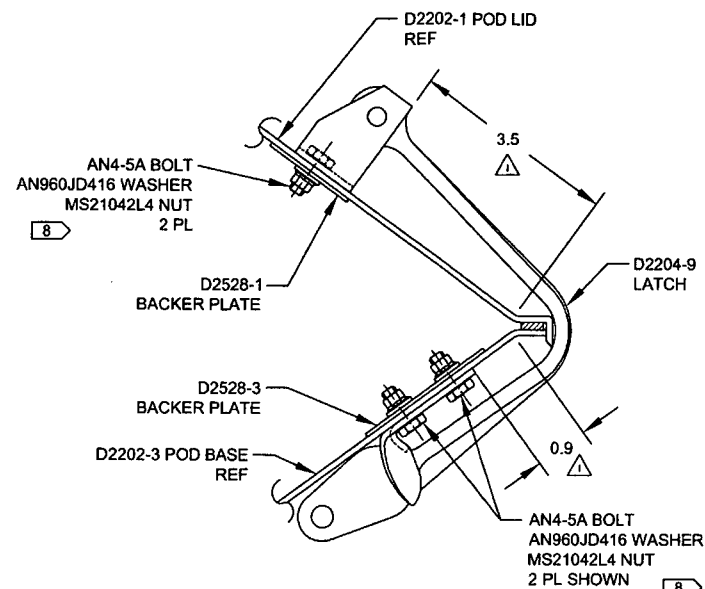
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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



SECTION C-C C3-2, C5-2
SCALE 10X



SECTION D-D C6-2
SCALE 10X

RELEASED
2010-04-29
MP

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D2694	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

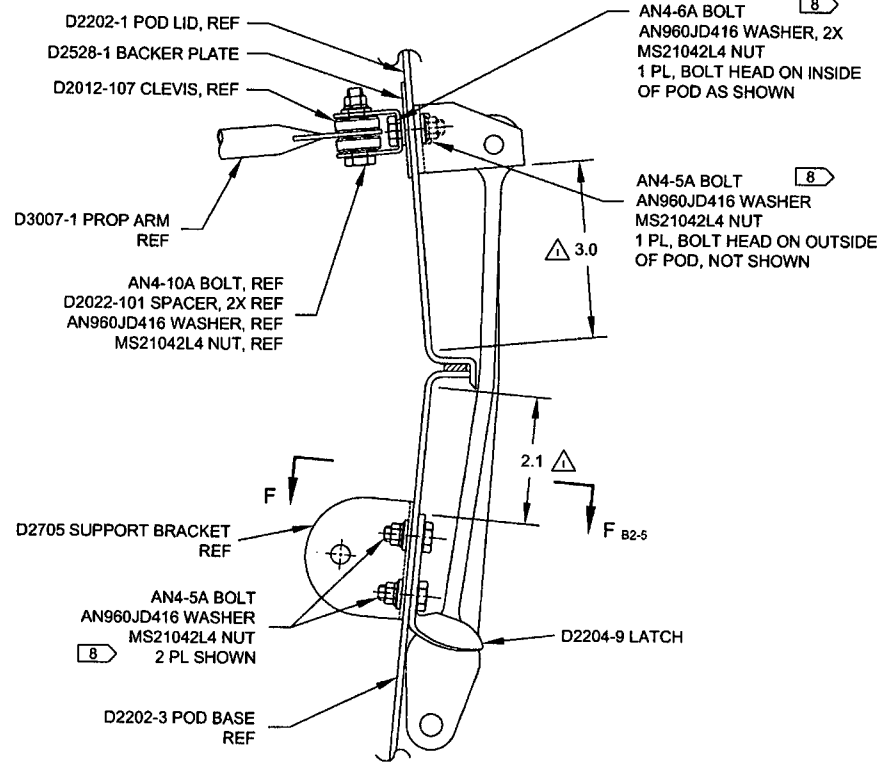
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

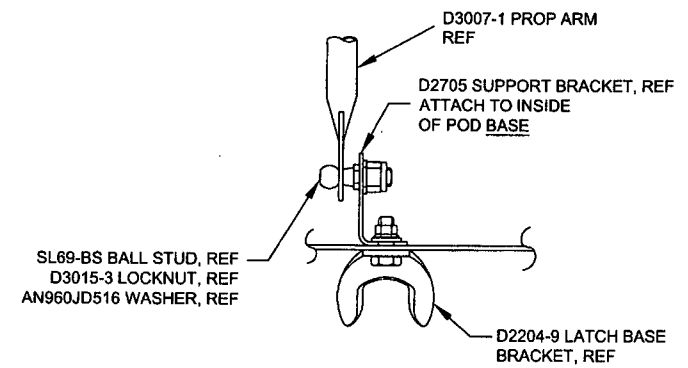
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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SECTION E-E C4-2
SCALE 10X



SECTION F-F B5-5
D3007-041 PROP ASS'Y DETAIL
SECTION ROTATED 85° CW

RELEASED
2010-04-29

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. 1
MFG. APPR.	JP	D2694	SHEET 5 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD ASSEMBLY	NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other